



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246



D206-667-247TRN
Job Sheet 202723



Part No: D206-667-247TRN Job Qty: 1 pcs
Part Name: Crosstube Assembly, Mid Aft

Part Weight: 0 lbs Status: New Priority: Medium
Job Created: 11/1/19 Job Tracking No:
Due Date: 11/22/19 Created By: Marie Lajeunesse
Type: Stock Description:
Note: DWG D206-667-247 REV.B IPP rev:A 11.01.06 new issue DD verf:EC
Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Lead Time	DAS	Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier				
100	Mori Seiki TL-40 - 1	1 pcs	11/22/19	11/22/19	1.00	1.33	Mori Seiki TL-40 - 1			66	2019/11/15
110	QC 2	1 pcs	11/22/19	11/22/19	0.00	0.00	QC 2 - 1			9-89	
							QC 2 - 12				
							QC 2 - 14				
							QC 2 - 17				
							QC 2 - 19				
							QC 2 - 2				
							QC 2 - 20				
							QC 2 - 22				
							QC 2 - 23				
							QC 2 - 25				
							QC 2 - 32				
							QC 2 - 33				
							QC 2 - 35				
							QC 2 - 39				
							QC 2 - 4				
							QC 2 - 40				
							QC 2 - 44				
							QC 2 - 45				
							QC 2 - 48				
							QC 2 - 49				
							QC 2 - 50				
							QC 2 - 51				
							QC 2 - 52				
							QC 2 - 57				
							QC 2 - 62				
							QC 2 - 63				
							QC 2 - 8				
							QC 2 - 66				
							QC 2 - 64				
							QC 2 - 65				

				QC 2 - 5	
				QC 2 - 71	
				QC 2 - 73	
				QC 2 - 69	
120	Mori Seiki TL-40 - 1 - B4B	1 pcs	11/22/19	1.00 1.33	Mori Seiki TL-40 - 1 - B4B
130	QC 2	1 pcs	11/22/19	0.00 0.00	QC 2 - 1
					QC 2 - 12
					QC 2 - 14
					QC 2 - 17
					QC 2 - 19
					QC 2 - 2
					QC 2 - 20
					QC 2 - 22
					QC 2 - 23
					QC 2 - 25
					QC 2 - 32
					QC 2 - 33
					QC 2 - 35
					QC 2 - 39
					QC 2 - 4
					QC 2 - 40
					QC 2 - 44
					QC 2 - 45
					QC 2 - 48
					QC 2 - 49
					QC 2 - 50
					QC 2 - 51
					QC 2 - 52
					QC 2 - 57
					QC 2 - 62
					QC 2 - 63
					QC 2 - 8
					QC 2 - 66
					QC 2 - 64
					QC 2 - 65
					QC 2 - 5
					QC 2 - 71
					QC 2 - 73
					QC 2 - 69
140	QC 8	1 pcs	11/22/19	0.00 0.00	QC 8 - 12
					QC 8 - 14
					QC 8 - 17
					QC 8 - 20
					QC 8 - 25
					QC 8 - 3
					QC 8 - 32
					QC 8 - 33
					QC 8 - 35
					QC 8 - 39
					QC 8 - 4
					QC 8 - 44
					QC 8 - 45
					QC 8 - 49
					QC 8 - 58
					QC 8 - 8
					QC 8 - 9
					QC 8 - 68
					QC 8 - 67
					QC 8 - 1 (A)

DAS
66204/11/18
9-89

DAS
66204/11/18
9-89

					QC 8 - 47	
					QC 8 - 40	
					QC 8 - 52	
					QC 8 - 23	
					QC 8 - 57	DAS
					QC 8 - 76	76
					QC 8 - 61	9-89
145 Crosstubes - 2 - B4B	1 pcs	11/22/19	0.00 0.50		Crosstubes - 1 - B4B	
					Crosstubes - 2 - B4B	BD 11/22/2019
					Crosstubes - 3 - B4B	
					Crosstubes - 4 - B4B	
150 Crosstubes - 3 - B4B	1 pcs	11/22/19	0.00 0.32		Crosstubes - 1 - B4B	
					Crosstubes - 2 - B4B	
					Crosstubes - 3 - B4B	★ NOV 26 2019
					Crosstubes - 4 - B4B	
160 QC 7	1 pcs	11/22/19	0.00 0.00		QC 7 - 10	
					QC 7 - 13	
					QC 7 - 14	
					QC 7 - 15	
					QC 7 - 17	
					QC 7 - 18	
					QC 7 - 19	
					QC 7 - 2	
					QC 7 - 28	
					QC 7 - 3	
					QC 7 - 30	
					QC 7 - 34	
					QC 7 - 36	
					QC 7 - 37	
					QC 7 - 41	
					QC 7 - 47	
					QC 7 - 48	
					QC 7 - 51	
					QC 7 - 58	
					QC 7 - 59	
					QC 7 - 60	
					QC 7 - 9	
					QC 7 - 68	
					QC 7 - 50	
					QC 7 - 67	
					QC 7 - 40	
					QC 7 - 24	
					QC 7 - 43	
					QC 7 - 61	DAS
					QC 7 - 81	76
					QC 7 - 76	9-89
					QC 7 - 79	
170 Packaging 3-1 - Stock - B4B	1 pcs	11/22/19	0.00 0.00		Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	

				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	BIS 11/26/2019
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
180 QC 21 - SA	1 pcs	11/22/19	0.00 0.00	QC 21 - SA - 21	DAS 21 9-08 NOV 26 2019
				QC 21 - SA - 70	
				QC 21 - SA - 53	

Part Op 100 - Mori Seiki CNC Lathe Large - 1-Fill tube with sand & install plugs 206-207 on both ends as per Folio FB030 2-Turn
Descriptions: first side as per Folio FB030 3-Blend transition line with belt sander 60 grit.
110 - QC2- Inspect parts off machine FAI/FAIB
120 - Mori Seiki CNC Lathe Large - 1-Turn second side as per Folio FB030 2-File down transition lines smooth.
130 - QC2- Inspect parts off machine FAI/FAIB
140 - QC8- Inspect parts - second check
145 - Crosstubes - GRIND ONLY TRANSITION LINES SMOOTH LONGITUDE WAY.
150 - Crosstubes - 1- handfinish X-TUBE INSIDE AND OUT
160 - QC7-Inspect Chemical Conversion Coat
170 - Identify as per dwg & Stock Location: _____ - LOCATION : LG014
180 - QC21- Final Inspection - Work Order Release

Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
D6004-115	Crosstube Material	1 pcs (1 ea)	100-Mori Seiki TL-40 - 1	F 107869

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-Mori Seiki TL-40 - 1	D6004-115	1	31	0

Part Specifications	
Specifications could not be found.	



Container No: S232301



Part: D206-667-247TRN

Job No: 202723

Serial No/Batch: S232301

Revision: B

Inspector:

Exp Date:

Instructions:

DART Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 813 632-8200
Email: sales@dartaero.com
www.dartaerospace.com

Plex 11/1/19 10:10 AM Dart.lajeunesse.marie

Date: 11/15/19

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DART AEROSPACE LTD	Work Order:	702723
Description: Crosstube Assembly, Mid Aft	Part Number:	D206-667-247
Inspection Dwg: D206-667-247 Rev: A		Page 1 of 2

FIRST ARTICLE INSPECTION CHECKLIST

Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
SIDE A	2.490	+0.005/-0.000	2.491	✓		CNC-04
	2.025	+0.005/-0.000	2.027	✓		
	2.079	+0.005/-0.000	2.084	✓		
	2.145	+0.005/-0.000	2.150	✓		
	2.209	+0.005/-0.000	2.214	✓		
	2.287	+0.005/-0.000	2.292	✓		
	2.363	+0.005/-0.000	2.367	✓		
	0.200	+/-0.010	.205	✓		CNC-08
	R0.063	+/-0.010	.063	✓		RG
	R2.00	+/-0.010	2.000	✓		
	R0.063	+/-0.010	.063	✓		
	4.438	+/-0.010	4.436	✓		CNC-08
SIDE B	2.490	+0.005/-0.000	2.490	✓		CNC-04
	2.025	+0.005/-0.000	2.026	✓		
	2.079	+0.005/-0.000	2.080	✓		
	2.145	+0.005/-0.000	2.150	✓		
	2.209	+0.005/-0.000	2.214	✓		
	2.287	+0.005/-0.000	2.292	✓		
	2.363	+0.005/-0.000	2.367	✓		
	0.200	+/-0.010	.201	✓		CNC-08
	R0.063	+/-0.010	.063	✓		RG
	R2.00	+/-0.010	2.000	✓		
	R0.063	+/-0.010	.063	✓		
	4.438	+/-0.010	4.438	✓		CNC-08
	99.76	+/-0.020	99.76	✓		Tape

Item	Qty	Part Number	Description
	-247		
1	X	D206-687-247	CROSSTUBE ASSEMBLY (206L MID AFT)
2	1	D6004-116	CROSSTUBE
3	2	D2873-043	NUT PLATE
4	2	D2873-045	NUT PLATE
5	2	D2882-1	SUPPORT
6	4	D3565-083-460	RUBBER CUSHION
7	4	MS21820-22	CLAMP
8	14	MS20601AD4W10	RIVET (OR NAS9302B-4-10)
9	AR	PROSEAL 880 B-2	SEALANT, AMIS-S-8802 CLASS B-2

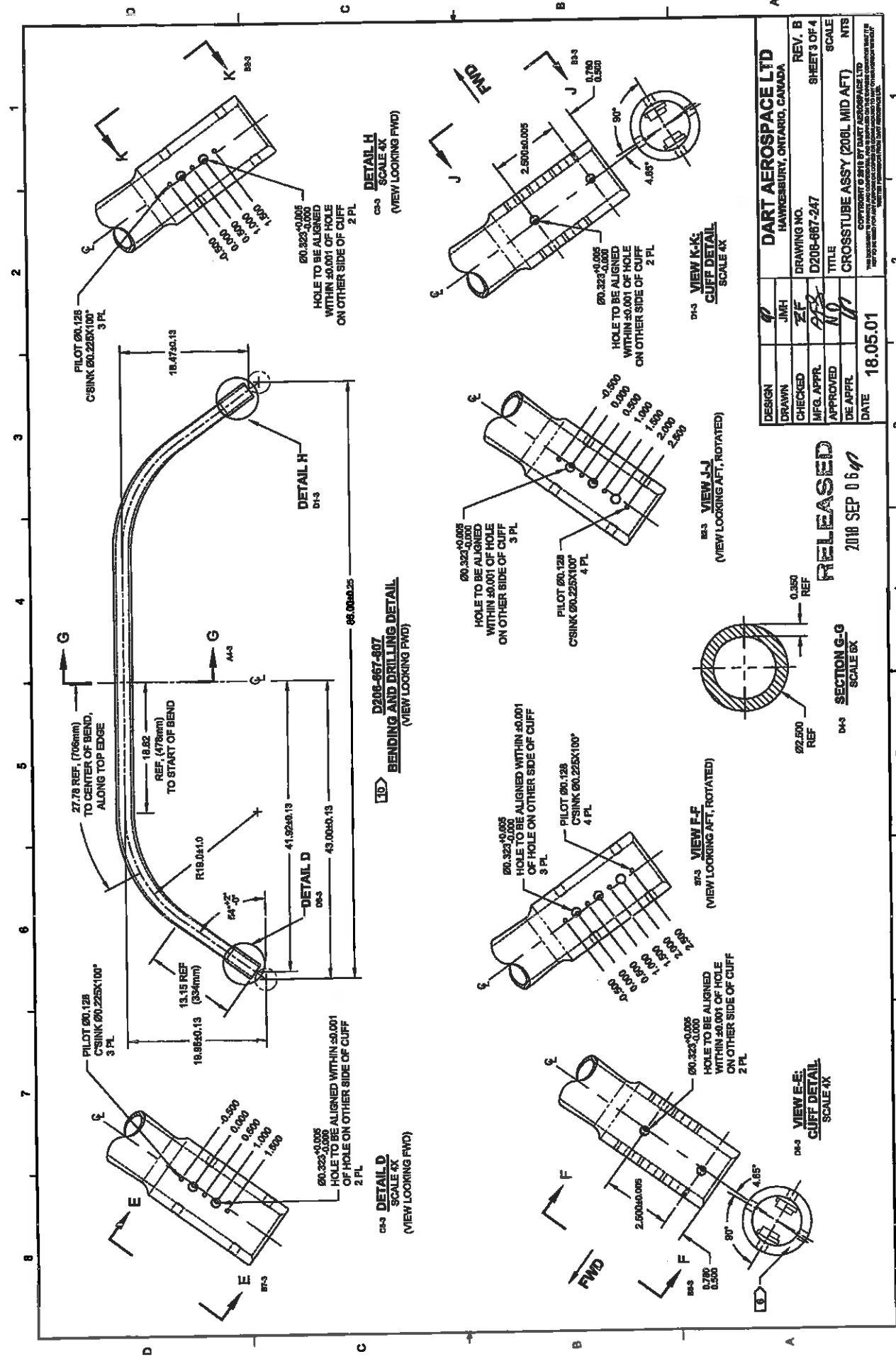
GENERAL NOTES:

- 1) MATERIAL: MANUFACTURED FROM D6004-116
FINISHED LENGTH = 99.7630.020
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
PAINT OUTSIDE PER DART QSI 005 4.2
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED.
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX.
- 6) IDENTIFICATION: SCRIBE DART PART NUMBER "D206-687-247" AND BATCH NUMBER ON INSIDE OF CLIFF PER DART QSI 044 6.4 (VIBRATING STYLUS).
- 7) WEIGHT: 21.1 lbs (-407 ± 17.7 lbs)
- 8) PART IS SYMMETRIC ABOUT CENTERLINE.
- 9) RUN CUTTER OFF PART WHERE INDICATED. BLEND OUT EDGE LONGITUDINALLY.
TRANSITION SHOULD BE SMOOTH.
- 10) BEND PROGRESSIVELY WITH A MINIMUM OF 8 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 6% BASED ON O.D.
- 11) LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038.
- 12) TO INSTALL D2882-1 SUPPORT: ABRASE MATING SURFACE OF SUPPORT AND CROSSTUBE WITH 180-GRIT SANDPAPER AND REMOVE RESIDUE WITH MEK (OR EQUIVALENT). APPLY A 0.04" TO 0.07" THICK LAYER OF PROSEAL 880 CLASS B-2 (OR AMIS-S-8802 CLASS B-2) SEALANT TO MATING SURFACE OF SUPPORT.
- 13) INSTALL MS21820-22 CLAMPS WITH D3565-083-460 RUBBER CUSHIONS TO SECURE THE D2882-1 SUPPORT ON TOP SIDE OF THE CROSSTUBE. ENSURE CLAMP MECHANISMS ARE LOCATED ON CROSSTUBE SUPPORTS.
- 14) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- 15) TORQUE CLAMPS 80 TO 100 IN-LB. ENSURE AT LEAST 1.5 THREADS ARE SHOWING IN SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TIGHTENING. PRIOR TO PACKAGING, RE-CHECK TORQUE ON CLAMPS AFTER PROSEAL 880 SEALANT HAS CURED FOR 72 HOURS.

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WITHOUT NOTICE
WORK ORDER
NO. 722723 MJS
19-11-01

B	REVISE SHEET 2 ASSEMBLY DETAIL HOLE PATTERN PER CART 8-221. UPDATE PARTS LIST AND GENERAL NOTES 12 & 15 TO INCORPORATE DEO A-1.	JMH	18.05.01
A	NEW ISSUE	CP	10.12.23
REV.	DESCRIPTION	BY	DATE
DESIGN		JMH	
DRAWN		JMH	
CHECKED		ZF	
MFG. APPR.		PTG	
APPROVED		NO	
DE APPR.		PT	
DATE	18.05.01		
DART AEROSPACE LTD HAMMERSBURY, ONTARIO, CANADA		REV. B	
DRAWING NO. D206-687-247		SHEET 1 OF 4	
TITLE CROSSTUBE ASSY (206L MID AFT)		SCALE	
		NTS	
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2018 SEP 06
BY 18-771



2018 SEP 06 09

D4-3 SECTION G-G
SCALE 6X

DESIGN	<i>Q</i>	DART AEROSPACE LTD HAMMERSBURY, ONTARIO, CANADA	
DRAWN	JMH	REV. B	SCALE
CHECKED	<i>ZF</i>	DRAWING NO.	SHEET 3 OF 4
MFG. APPR.	<i>Q</i>	D208-687-247	NTS
APPROVED	<i>Q</i>	TITLE	CROSS-TUBE ASSY (208L MID AFT)
DE APPR.	<i>Q</i>	COPYRIGHT © 2010 BY DART AEROSPACE LTD.	
DATE	18.05.01	THIS DOCUMENT IS UNCLASSIFIED AND IS RELEASED ON 10-15-10 BY THE NATIONAL ARCHIVES AND RECORDS SERVICE	

Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only



Job: _____ Part No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐		DEPARTMENT/PROCESS Skid-tube ☐ Cross tube ☐ Eng. (Non-AW) ☐ Machining ☐ Small Fab ☐ Prod. Eng. Coord. ☐ Large Fab ☐ Finishing ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)			
Description Work Order Deviation		Disposition		Completed By			
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Other/Details: _____		Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread ☐		Lead hand / Supervisor	
						QC / QA Coordinator	